

## IN THE CLAIMS

Please amend the claims as follows:

1. (original) A bumper (2) for a vehicle, including a beam (4) that has at least one synthetic material, characterised in that it includes an insert (6) to accommodate a towing ring (40).
2. (currently amended) A bumper according to ~~the preceding claim~~claim 1, characterized in that the insert (6) is fixed directly onto the beam (4).
3. (currently amended) A bumper according to ~~any one of the preceding claims~~claim 1, characterized in that the insert (6) is accommodated in a housing (16) made of synthetic material.
4. (currently amended) A bumper according to ~~the preceding claim~~claim 3, characterized in that the synthetic material is in contact with the insert (6) over the whole of the housing (16).
5. (currently amended) A bumper according to ~~any one of claims 3 to 4~~claim 3, characterized in that the housing (16) is in the form of a sleeve.
6. (currently amended) A bumper according to ~~any one of the preceding claims~~claim 1, characterized in that the insert (6) has a small collar (32).
7. (currently amended) A bumper according to ~~any one of the preceding claims~~claim 1, characterized in that the insert (6) has one end crimped (34).
8. (currently amended) A bumper according to ~~any one of the preceding claims~~claim 1, characterized in that the insert (6) includes a metal.
9. (currently amended) A bumper according to ~~any one of the preceding claims~~claim 1, characterized in that the beam (4) is composed of at least one synthetic material.
10. (currently amended) A bumper according to ~~any one of the preceding claims~~claim 1, characterized in that the beam (4) includes reinforcing fibres.
11. (currently amended) A bumper according to ~~any one of the preceding claims~~claim 1, characterized in that the insert (6) is secured to an absorber (10) on the beam (4).
12. (currently amended) A bumper according to ~~any one of claims 1 to 10~~claim 1, characterized in that the insert (6) is secured to a bar (5) on the beam (4).
13. (original) A process for the manufacture of a bumper (2) for a vehicle, characterized in that an insert (6) is placed to accommodate a towing ring (40) in a bumper that includes a beam (4) that has at least one synthetic material.

14. (currently amended) A process according to ~~the preceding claim~~claim 13, characterized in that the insert (6) is fixed directly to the beam (4).
15. (currently amended) A process according to ~~any one of claims 13 or 14~~claim 13, characterized in that the ~~(or each)~~ material intended to form the beam is heated, and is then placed in a mould (60).
16. (currently amended) A process according to ~~the preceding claim~~claim 15, characterized in that the ~~(or each)~~ material is compressed when the mould is closed (60).
17. (currently amended) A process according to ~~either of claims 15 or 16~~claim 15, characterized in that a space-forming part (62) is moved within the mould to form a housing (16).
18. (currently amended) A process according to ~~the preceding claim~~claim 17, characterized in that the movement takes place after closure of the mould.
19. (currently amended) A process according to ~~either of claims 17 or 18~~claim 17, characterized in that insert (6) is positioned in the housing (16).
20. (currently amended) A process according to ~~any one of claims 17 to 19~~claim 17, characterized in that the insert (6) is positioned in the housing (16) while the beam (4) is at a temperature greater than ambient temperature.
21. (currently amended) A process according to ~~any one of claims 13 to 20~~claim 13, characterized in that the insert is crimped (6) onto the beam (4).
22. (original) A mould for the manufacture of a beam (4) for vehicle bumpers (2), including a chassis (67), characterized in that it includes a space-forming part (62) mounted to be mobile in a cavity (61) of the mould in relation to the chassis.